

Work Order ID 152707

Friday, November 04, 2016 3:02:02 PM

152707

Page 1

Item ID: D5395-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 11/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/11/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: em Date: 16/11/4 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5395	A								
100	FLOW WATER JET	0.01							PR 16/11/04
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

NOV 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
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130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.03 0.00			DAS 30 9-89	①			NOV 07 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 NOV 07 2016
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M 134798 Memo ***MASK HOLES PRIOR TO POWDERCOAT AS PER DWG NOTE 8*** START TIME: <u>2:00</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>2:30</u>	0.00 0.00				1	φ 16-11-7	DAS 34 9-89	

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160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.02				1			DAS 38 NOV 08 2016
Quality Control									
170	Identify as per dwg & Stock Location: <u>51167</u>	0.00							
170									
Packaging	Memo	0.00							NOV 8 7 2016 DAS 6 9-89
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							16/11/9
Quality Control									16-11-09

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Picklist Print

Friday, November 04, 2016 3:02:02 PM

Page 1

Work Order ID: 152707

152707

Parent Item: D5395-1

D5395-1

Parent Item Name: Bracket

Start Date: 11/7/2016

Required Date: 11/11/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.02.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased		No			sf	32.5930		0.013158			

M304S12GA

304/316 0.100" Sheet

PR 16/11/04

Location

Loc Qty

Loc Code

MAT019

32.593

m131322

4.723

m135344

27.87

0.01

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8 7 6 5 4 3 2 1

D

D

C

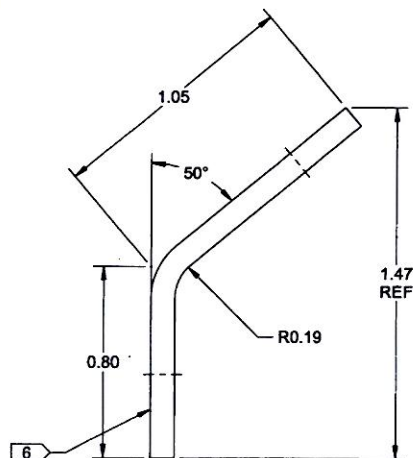
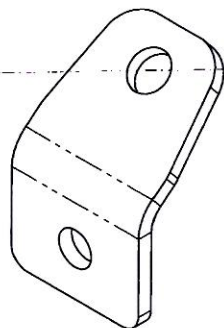
C

B

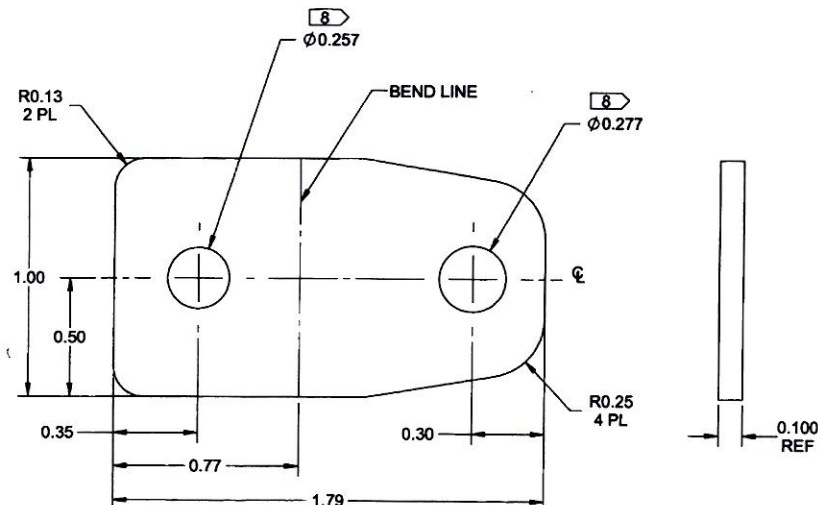
B

A

A



D5395-1 BRACKET
(MAKE FROM D5395-1F)



D5395-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152707

sem 16/11/4

NOTES:

- 1) MATERIAL: AISI 303/304/316 STAINLESS STEEL SHEET, 0.100 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S12GA OR M303S12GA
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

RELEASE
2016-02-08
sem 16-520

APPROVED

A NEW ISSUE		RF	16.01.27
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5395	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	16.01.27		

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8 7 6 5 4 3 2 1